



DELFLLEET® Evolution

F3993/95/97

Conventional Epoxy Primer
Gray/Buff/Black

F3993/95/97 series are chrome-free, high performance and general-purpose primers, which can be used on a variety of substrates used in the commercial market. These pigmented epoxy primers provide excellent adhesion when applied to properly prepared compatible surfaces listed below, as well as plastic fillers.

Products

Conventional Epoxy Primer-(Gray)	F3993
Conventional Epoxy Primer-(Buff)	F3995
Conventional Epoxy Primer-(Black)	F3997
Conventional Epoxy Primer Hardener	F3996
Fast Thinner	F3320
Medium Thinner	F3330
Slow Thinner	F3340
Extra Slow Thinner	F3350
Retarder	F3360

Additional Reducer Options*

Fast Reducer*	F3311
Reducer – Medium*	F3321
Reducer – Slow*	F3331
Reducer – Hot Temperature*	F3341
Retarder*	F3351

* Some reducer options contain volatile HAP (VoHAP). They may be used in areas where VoHAP content is not severely restricted

Compatible Surfaces

F3993/95/97 may be applied over:

- Properly cleaned and sanded: steel, aluminum, galvaneal, galvanized, stainless steel, OEM finishes, fiberglass and cured finishes.
- F3950 High Solids Epoxy Primer
- F3970 Ultra High Solids Primer
- F3980 High Solids Primer
- F4921 2.1 VOC Epoxy Primer
- F4935/36/37 High Solids Epoxy Primers

When sanding bare metal areas prior to application of F3993/95/97, use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry.

Always use fresh sandpaper and thoroughly clean all substrates after sanding.

Aluminum, stainless and carbon steel must be primed immediately after cleaning and sanding.

F3993/95/97

Application Data

Selection of Substrate Cleaner:



**ONECHOICE®
Commercial CFX
Cleaners**

Code	Product	Purpose
CFX435LV	Low Voc Cleaner	Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process.

Mixing Ratio:



F3993/95/97 : F3996 : F33XX
3 : 1 : 1/2

A 30-minute induction time or extended agitation after blending is recommended for optimum performance.

Pot Life @ 70°F (21°C) / 50% RH:



6 hours

High heat and humidity will shorten pot life.

Spray Viscosity:



#2 ZAHN CUP	#3 ZAHN CUP	4DIN	6DIN
40–45 seconds	12–16 seconds	22–26 seconds	9–11 seconds

Spray Gun Set-up:



	HVLP	COMPLIANT
Fluid Tip:	1.3–1.5 mm	1.3–1.5 mm
Air Pressure:	8–10 PSI at the cap	40–50 PSI

Number of Coats:



1–3 coats

F3993/95/97

Application Data continued

**Flash Off @ 70°F (21°C)
before force drying:**



15 minutes

Dry Times:



Dust-Free: 10 minutes



Tape Time:

70°F (21°C) 4 hours

140°F (60°C) 30 minutes



Overcoat/Recoat: 60 minutes – 72 hours (Max. before sanding is required)

70°F (21°C)

** Force dry times are for quoted metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.*

Film Build:

	Wet (per coat)	Dry (total)
Minimum	2.5 mil	1.0 mil
Maximum	5.0 mil	2.0 mil

Theoretical Coverage:

560–570 sq. ft.

Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency).

Performance Comments:

A 30-minute induction time or extended agitation after blending is recommended for optimum performance.

Physical Characteristics:

VOC (Packaged):	F3993/95/97	4.13 lbs./gal. or 493 g/L
	F3996	4.75 lbs./gal. or 568 g/L
	F33XX	7.13 lbs./gal. or 856 g/L
VOC (Ready-To-Spray):	4.60 lbs./gal. or 550 g/L	
Total Solids By Weight (RTS):	54–57%	
Total Solids By Volume (Packaged):	F3993/95/97	
	F3993:	41.95%
	F3995:	41.98%
	F3997:	41.66%
	F3996:	33.45%
Total Solids By Volume (RTS):	35–36%	

Health and Safety:

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.

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